

Work Order ID 59886

Tuesday, June 15, 2010 2:16:30 PM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 6/15/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

10-6-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3282

Rev C

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
per QSI0018

☐ 2- inspect for surface damage as

10 - - AW 17
10-06-16

PT077

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282 ☐ 2-Deburr

ml 10/06/30

10/07/01

9

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 10/06/30

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: _____ Fault Category: Machining NCR: (Yes) No DQA: / Date: 10.07.13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 10.07.13

NCR: 59886		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/01	110	Compressor goes off by missing electricity then tool bite in parts so lift the part from jig, causing 0.050" deep damage. R.C. process / Power outage / Flash / other.	<u>/</u> 10/11/12	Scrap is replace. Qty 1	<u>SL</u> 10/07/01	<u>SL</u> 10/07/01	<u>/</u> 10/11/12	<u>/</u> 10/07/01

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 10/07/07

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

9 11/07/18

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10-7-12 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59886

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Start Date: 6/15/2010 Start Qty: 10.00

Required Date: 6/18/2010 Req'd Qty: 10.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Skidtubes	Skidtubes	0.00				9		110/7/12	
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web □ A/RN/ALPS-3 <u>M154929</u>								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
180  Packaging	Identify as per dwg & Stock Location: <u>L.B.</u>	0.00							
Packaging	Memo	0.00							

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Page 4

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Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

21007-13

ME

10-7-13

Picklist Print

Tuesday, June 15, 2010 2:16:34 PM

Page 1

Work Order ID: 59886

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 6/15/2010

Required Date: 6/18/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-7

Purchased

No

100

Each

1,864.000

57

570



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

1864

112492

1864

D2792-130

Manufactured

No

160

Each

18.0000

1

10



EXTRUSION

Location

Loc Qty

Loc Code

MAT06

18

42366

18

D3283-1

Manufactured

No

160

Each

22.0000

2

20



Doubler

Location

Loc Qty

Loc Code

ST048

22

57725

22

18 M 10/17/8

515 M 10/17/12

AWM 10-06-16 10

DART AEROSPACE LTD		Work Order:	59886
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.625	/			
1.500	+/-0.010	1.498	/			
3.000	+/-0.010	2.996	/			
6.000	+/-0.010	5.996	/			
1.250	+/-0.010	1.248	/			
30.000	+/-0.010	30.000	/			
1.500	+/-0.010	1.497	/			
72.01	+/-0.030	72.990	/			
61.75	+/-0.030	61.740	/			
57.50	+/-0.030	57.490	/			
49.19	+/-0.030	49.180	/			
43.94	+/-0.030	43.930	/			
39.69	+/-0.030	39.690	/			
26.68	+/-0.030	26.680	/			
0.55	+/-0.030	.550	/			
1.970	+/-0.010	1.973	/			
2.38	+/-0.030	2.376	/			
0.05	+/-0.030	.050	/			

Measured by:	owl
Date:	10/06/30

Audited by:	SL
Date:	10/07/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

SHOP

RETURN

ENGINEER

UNCONTROLLED

SUBJECT TO APPROVAL

WITH OUT

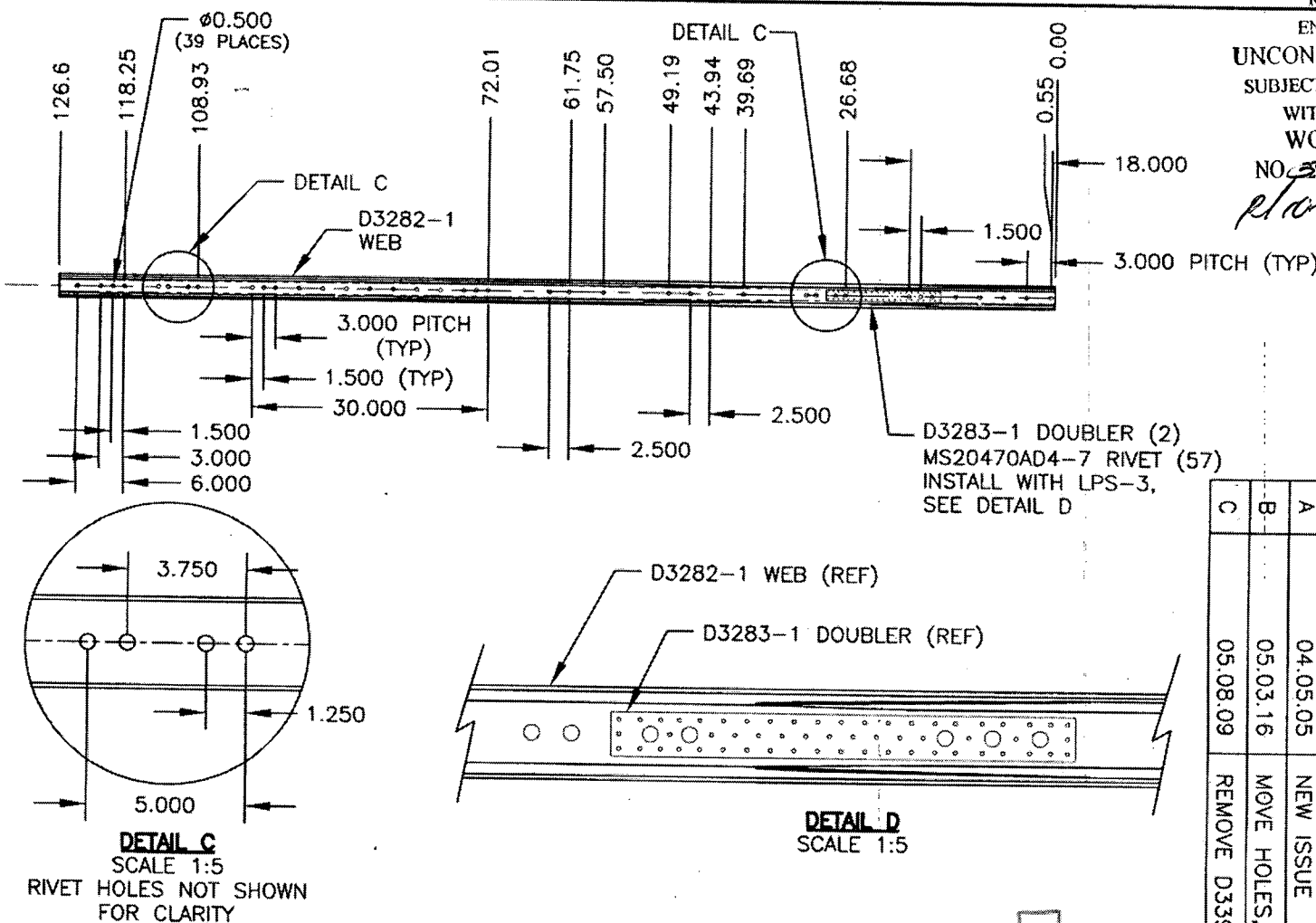
WORK

NO. 8888

10/15

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3282
DATE	DATE	TITLE
05.08.09	04.05.05	NEW ISSUE
	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
	05.08.09	REMOVE D3390-1, NOW MACHINED
		SCALE
		1:20
		SHEET 1 OF 2
		REV. C



D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED
05.09.12

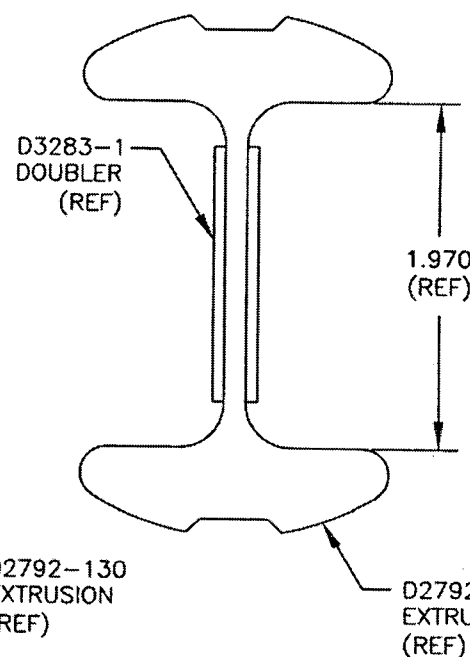
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DART

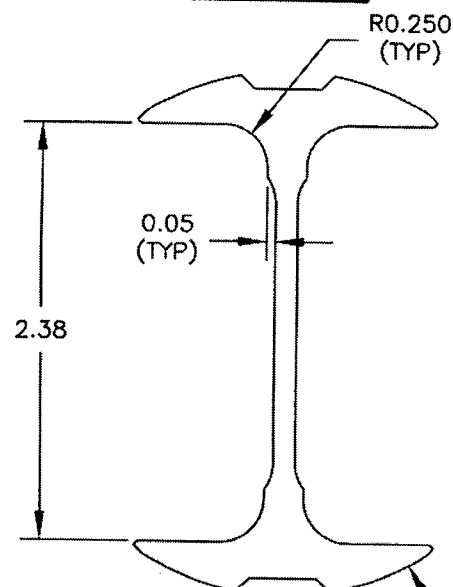
w/o 59889

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20
				FLOAT WEB, 206L/407

SECTION B-B

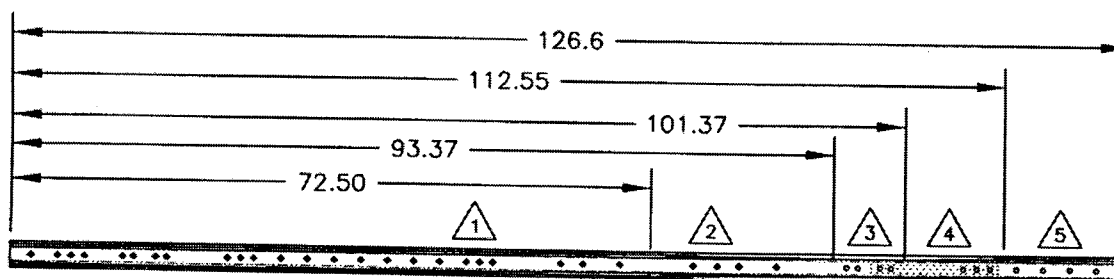


SECTION A-A



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05/04/12